

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013687**Date Inspected:** 26-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG COMPONENT				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay#19

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-594-001. The welder is identified as #062788. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-596-002. The welder is identified as #062807. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG U-rib connecting plate, weld No.USPL1-599-001. The welder is identified as #062783. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Suspender Bracket SB52E, weld No.SB014-052-005.The welder is identified as #062749. ZPMC QC is identified as Mr. Zhoe Chang . The welding variables recorded by QC appear

WELDING INSPECTION REPORT

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to comply with WPS-B-T-2232-Tc-U4b-F.

During in-process observations of the Cross Beam Bottom panels being fabricated in bay 19, the Caltrans Quality Assurance Inspector (QA) observed that the Cross Beam Bottom panels distortion due to improper storage in Bay 19. The Crossbeam bottom plate material is A709 Grade 345 Seismic Performance Critical Material (SPCM). For more information see the attached photo.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG Cross Beam Bottom Plate to Stiffener. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

BP026-010-004~023,044~053

BP026-012-004~023,044~053

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as OBG Cross Beam Bottom Plate to Stiffener.

OBG Bottom Plate Green Tag

BP026-010-004~023,044~053 12344

BP026-012-004~023,044~053 12341

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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